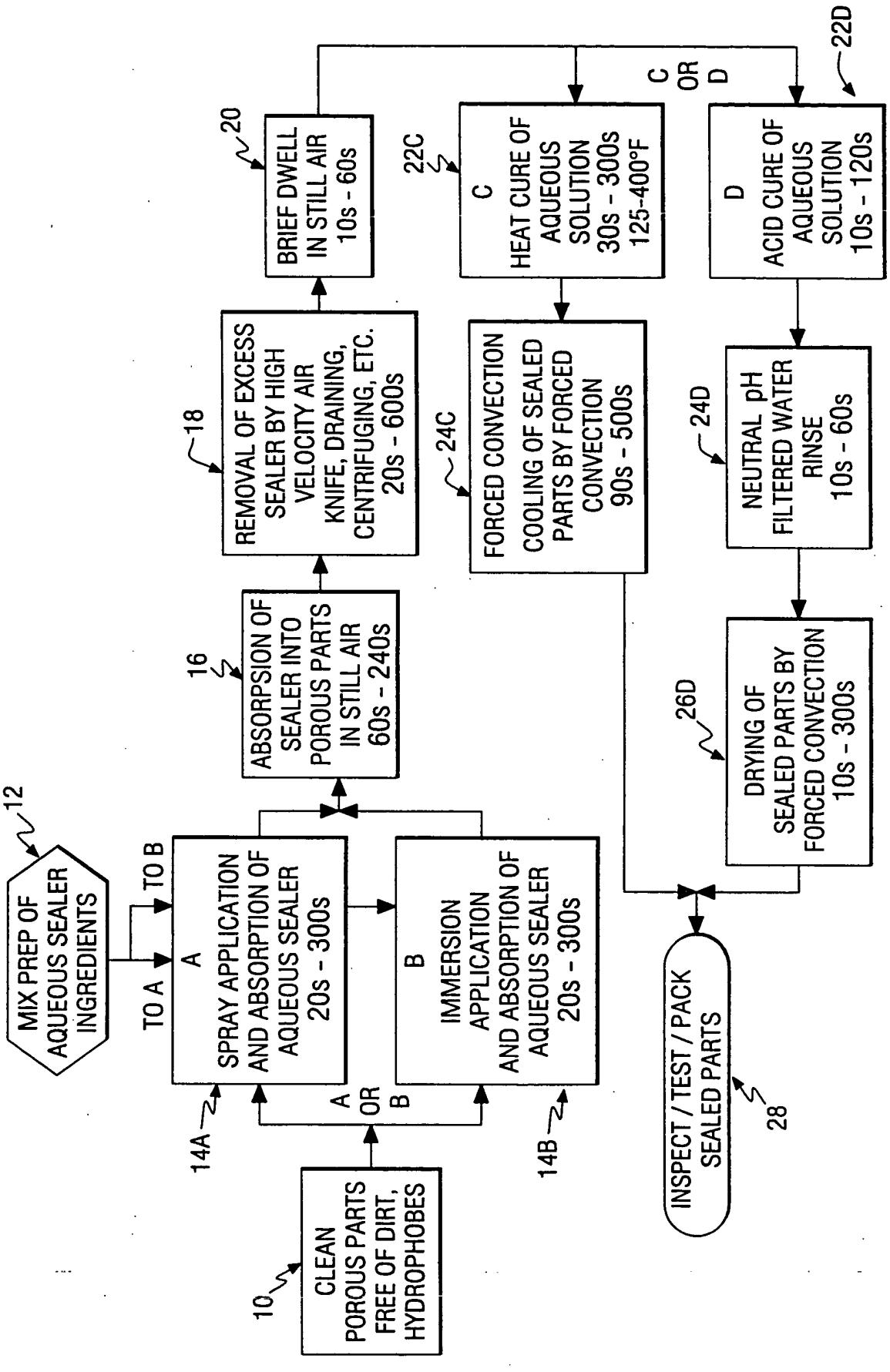
10
CLEAN POROUS PARTS FREE OF DIRT, HYDROPHOBES
A OR B
14A
14B
12
MIX PREP OF AQUEOUS SEALER INGREDIENTS
TO A
TO B
A SPRAY APPLICATION AND ABSORPTION OF AQUEOUS SEALER 20s - 300s
B IMMERSION APPLICATION AND ABSORPTION OF AQUEOUS SEALER 20s - 300s
16
ABSORPSION OF SEALER INTO POROUS PARTS IN STILL AIR 60s - 240s
18
REMOVAL OF EXCESS SEALER BY HIGH VELOCITY AIR KNIFE, DRAINING, CENTRIFUGING, ETC. 20s - 600s
20
BRIEF DWELL IN STILL AIR 10s - 60s
C OR D
22C
C HEAT CURE OF AQUEOUS SOLUTION 30s - 300s 125-400°F
22D
D ACID CURE OF AQUEOUS SOLUTION 10s - 120s
24C
FORCED CONVECTION COOLING OF SEALED PARTS BY FORCED CONVECTION 90s - 500s
24D
NEUTRAL pH FILTERED WATER RINSE 10s - 60s
26D
DRYING OF SEALED PARTS BY FORCED CONVECTION 10s - 300s
28
INSPECT / TEST / PACK SEALED PARTS